Work Order ID 74269

Tuesday, September 27, 2011 1:19:06 PM

Item ID: D4073-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Door Hinge Backing Plate

Start Date: 9/27/2011 **Start Qty:** 80.00 **Cust Item ID:**

Required Date: 10/7/2011 **Req'd Qty:** 80.00 **Customer:**

Reference:

Approvals: **Process Plan:** W **Date:** **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4073 / B									
100		0.00							
Waterjet		0.00							B11-9-27
FLOW CNC Waterjet	**Memo**								
6061 . 063	1-Cut as per Dwg Dwg Rev: B Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC		0.00							B11-9-27
Quality Control	**Memo**								

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Item Name: Door Hinge Backing Plate

Start Date: 9/27/2011 **Start Qty:** 80.00 **Cust Item ID:**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:**_____ **Tooling:** _____ **Date:**_____

QC: _____ **Date:**_____ **SPC (Y/N):** _____ **Date:**_____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				counts (92)			
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				92 BK 11-9-28.			
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum **Memo** POWDER COAT: Start Time: 3:45 Oven Temperature: 320 Finish Time: 4:15	0.00 0.00				92 ✓ M 11/10/03			

M 118434

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 74269

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				92 counted	0		ML 11/10/11
QC	**Memo**	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: ST 120	0.00				SO 11-10 = 4			
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							11/10/11
QC	**Memo**	0.00							
Quality Control									

MF 11-10-11

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 1:19:03 PM

Work Order ID: 74269

Parent Item: D4073-3

Parent Item Name: Door Hinge Backing Plate

Start Date: 9/27/2011 **Required Date:** 10/7/2011

Start Qty: 80.00 **Required Qty:** 80.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:EC IPP REV:B
DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS
VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	136.9456	0.02777	2.338526			
6061-T6 .063 Sheet													

Location	Loc Qty	Loc Code
MAT021	136.9455684	
116308	26.9755684	
117285	98.97	
118580	11	

B 11-9-07

92

117285

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

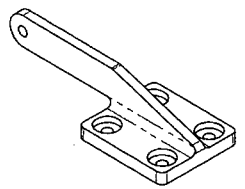
DART AEROSPACE LTD	Work Order:	74269
Description: Door Hinge Backing Plate	Part Number:	D4073-3
Inspection Dwg: D4073 **Rev:** B		Page 1 of 1

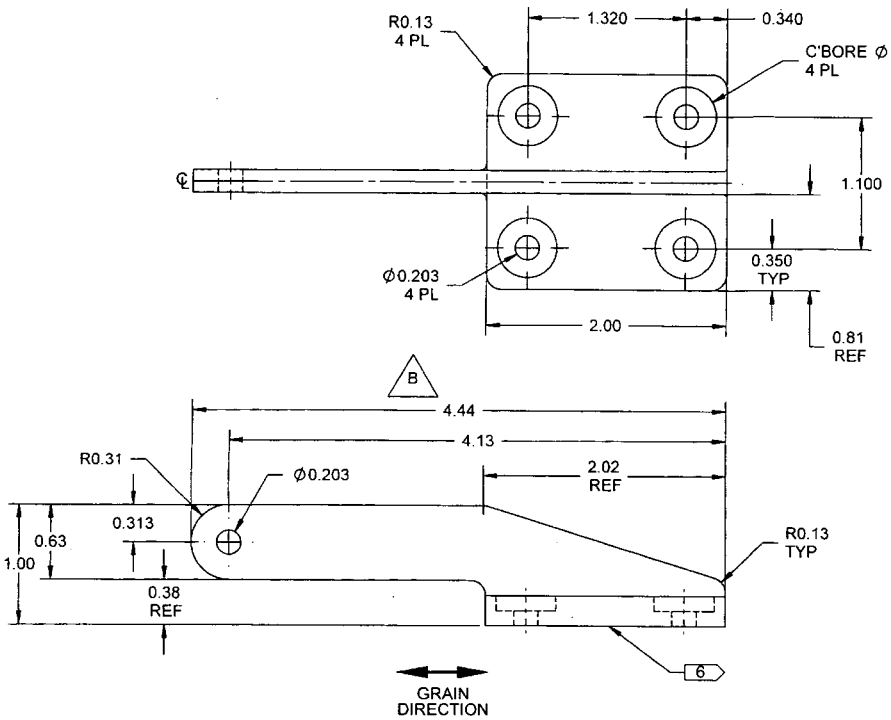
FIRST ARTICLE INSPECTION CHECKLIST

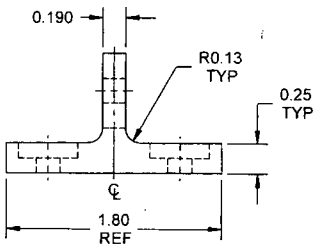
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.203	+0.005/-0.001	.205	✓		V HBZ	
2.00	+/-0.030	2.006	✓		V	
1.320	+/-0.010	1.322	✓		V	
0.34	+/-0.030	.344	✓		V	
0.35	+/-0.030	.353	✓		V	
1.80	+/-0.030	1.808	✓		V	
1.100	+/-0.010	1.096	✓		V	
0.063	+/-0.010	.064	✓		V	

Measured by:	PB	Audited by:	✓	Preliminary Approval:	
Date:	11-9-07	Date:	11/09/26	Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ	
B	11.07.26	Dwg Rev updated	KJ	







D4073-1 DOOR HINGE

RELEASED
2011-06-30

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.12 lbs

REV.	DESCRIPTION	BY	DATE
B	4.44 WAS 3.75; 4.13 WAS 3.44 (ZN C6-1)	RF	11.05.02
A	NEW ISSUE	RF	10.09.16

DESIGN		DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED		DRAWING NO. D4073 REV. B
MFG. APPR.		SHEET 1 OF 2
APPROVED		TITLE DOOR HINGE SCALE NTS
DE APPR.		
DATE	11.05.02	

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Dart Aerospace Ltd

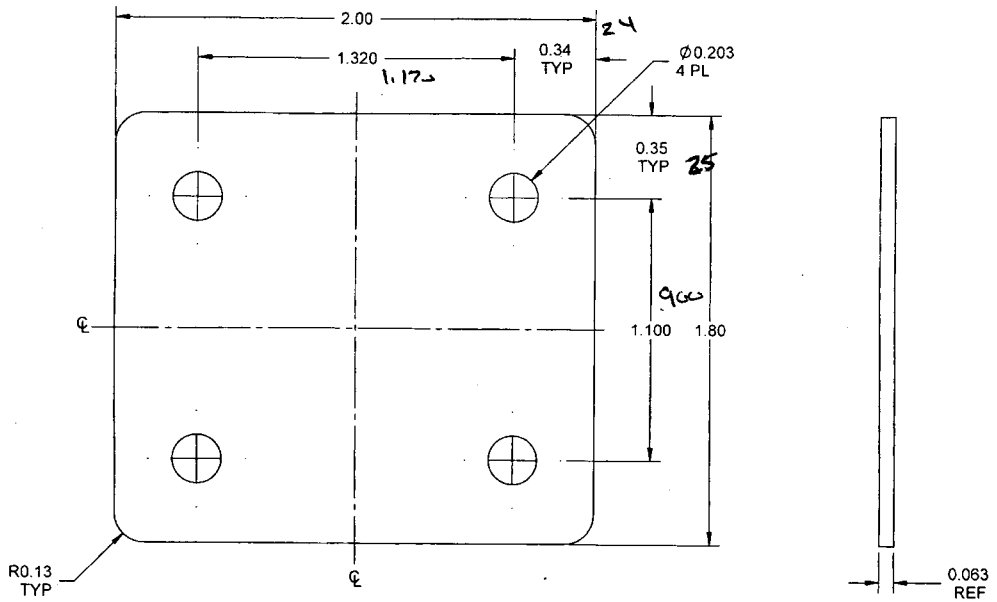
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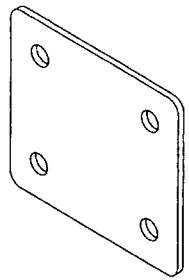
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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries





D4073-3 DOOR HINGE BACKING PLATE

RELEASED
2011-06-30

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED		DRAWING NO. D4073 REV. B
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE DOOR HINGE SCALE NTS
DE APPR.		
DATE	11.05.02	

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